

Work Order ID: 84656

May-30-12 3:54:12 PM

Duplicate

84656

U/R

Page 1

Item ID: D350-748-141TRN

Accept

N9000040100

Setup Start

NS1

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop

NS2

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/31

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-748-141

FUR OK 12-05-31

100

0.00

100

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3- File transition lines smooth.

FOLIO REV: 1/14

DWG REV: 1

1 6 KE 12-11-26

Pto →

110

QC1- Inspect dimensions to dimension sheet

0.00

110

QC

Memo

0.00

Quality Control

1 9 KE 12-11-26

W/O: 84656		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-141TRN PAR #: _____ Fault Category: Process / Material NCR: Yes No DQA: OK Date: 13/02/07
 Resolution: 13-2299 Disposition: Use as is QA: N/C Closed: OK Date: 11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/12/4	100	Ultra sonic wall measurement is over tolerance at one location.	DAS 12 2-83 12/12/4	Min wall is within 0.020 of dwg nominal (0.126) Acceptable	DAS 12 2-83 12/12/4	JW 12-12-10	DAS 12 2-83 13/1/31	S 13/2/5
		R.C. Material						

NOTE: Date & initial all entries

Work Order ID 84656

84656

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May-30-12 3:54:12 PM

Item ID: D350-748-141TRN

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop

NS2

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

120

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA648
2- File transition lines smooth.
3-Scribe Part & Batch as per Dwg D350-748-141
FOLIO REV: MA
DWG REV: F

1 0

man.l
12/11/28

130

QC1- Inspect dimensions to dimension sheet

0.00

130

QC

Memo

0.00

Quality Control

1 0

man.l
12/11/28

140

QC8- Inspect parts - second check

0.00

140

QC

Memo

0.00

Quality Control

JW 12-12-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84656

84656

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Item ID: D350-748-141TRN

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop

NS2

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Large Fab

0.00

Crosstubes

Memo

1-DRILL HOLES FOR HEAT TREAT USING DT9806(HOLES MUST BE
ALIGNED ON SAME LINE ON BOTH CUFFS)

> RM 12-12-12

Crosstubes

2-Grind machining marks

> RM

12-12-12

160

0.00

160

Outsource process - Heat Treat

0.00

Outsource

Memo

Issue P/O: # 18654
Heat Treat to min 180 KSI As per Dwg D350-748-141
(MIL-T-6736 OR AMS 2759-1C)
Sand Blast tube after Heat Treat
Possible Supplier: Vac Aero
Ensure Certificate of Conformity is attached

RM 12-18-12

Outsource process - Heat Treat

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84656

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May-30-12 3:54:12 PM

Item ID: D350-748-141TRN

Accept

N900040100

Setup Start *NS1*

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop *NS2*

Start Date: 17/05/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

Receive & Inspect for Damage & Mat'l Certs

0.00

170

Packaging

Memo

0.00

Packaging

Ensure certificate of conformaty is attached

13/01/21 (1)

180

QC6- Inspect dimensions to drawing

0.00

180

QC

Memo

0.00

Quality Control

DAS 16 13/1/24

190

Packaging

0.00

190

Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack
Location: LG

① S4013-01-37

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84656

84656

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May-30-12 3:54:12 PM

Item ID: D350-748-141TRN

Accept

N900040100

Setup Start

NS1

Revision ID: U/R

Item Name: Crosstube Turning Detail

Stop

NS2

Start Date: 17/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

13/1/31 20
MLJ 13-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-30-12 3:54:17 PM

Page 1

Work Order ID: 84656

84656

Parent Item: D350-748-141TRN

D350-748-141TRN

Parent Item Name: Crosstube Turning Detail

Start Date: 17/05/2012

Required Date: 22/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-03-06 DD verified by:ec
 IPP Rev B Removed polish 08.04.02 EC verified by : DD
 IPP Rev C Remove LPS-3 08.06.23 EC verified by DD IPP Rev C
 11.02.24 as per dwg rev.F DD verf: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6015-125		Manufactured	No			110	Each	38.0000	1	1			
D6015-125									**				
Crosstube Material													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
HALL	38	
61380	4	
72511	34	

81022

1

KC-12-11-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 84656
Description: Crosstube Assembly (AS350/355 High Fwd)	Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.242	-	vern	CWL-08
	2.180	+0.005/-0.000	2.184	-		
	2.180	+0.005/-0.000	2.183	-		
	2.237	+0.005/-0.000	2.241	-		
	2.272	+0.005/-0.000	2.276	-		
	2.306	+0.005/-0.000	2.311	-		
	2.339	+0.007/-0.000	2.342	-		
	2.339	+0.007/-0.000	2.345	-		
	0.062	+/-0.010	063	-	vern	CWL-08
	4.26	+/-0.030	4.26	-	"	
	R0.063	+/-0.010	063	-	RG	
	R0.50	+/-0.030	.500	-	"	
SIDE B	2.240	+0.005/-0.000	2.241	-	vern	CWL-08
	2.180	+0.005/-0.000	2.182	-		
	2.180	+0.005/-0.000	2.183	-		
	2.237	+0.005/-0.000	2.241	-		
	2.272	+0.005/-0.000	2.277	-		
	2.306	+0.005/-0.000	2.311	-		
	2.339	+0.007/-0.000	2.340	-		
	2.339	+0.007/-0.000	2.344	-		
	0.062	+/-0.010	063	-	vern	CWL-08
	4.26	+/-0.030	4.26	-	"	
	R0.063	+/-0.010	063	-	RG	
	R0.50	+/-0.030	.500	-	"	
	110.27	+/-0.060	110.25	-	TAPE	TAPE 16-15

Measured by: KJ/JLM	Audited by: JW	Preliminary Approval:
Date: 12/11/27	Date: 12-12-10	Date:

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	
D	11.07.26	Tolerance revised for 2.339 dimensions	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

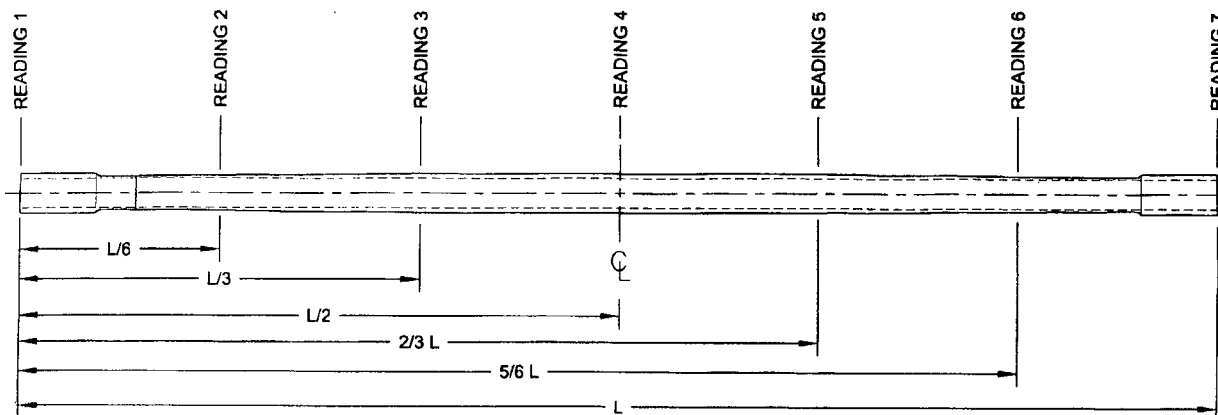
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 841656
Description: Crosstube Assembly (AS350/355 High Fwd)		Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: F		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.126	.120	.120	.124	.008	0.030"
READING 2 L= 11	.101	.118	.104	.089	.029	
READING 3 L= 22	.134	.115	.149	.129	.034	
READING 4 L= 55	.172	.186	.178	.172	.008	
READING 5 L= 22	.134	.135	.150	.150	.016	
READING 6 L= 11	.089	.096	.116	.111	.027	
READING 7 L= cur	.124	.116	.125	.133	.017	

Calibration Result

Actual Block Thickness: .100-.500

Sitiescan 250 Measured Thickness: .100-.500

Measured by: <i>[Signature]</i>
Date: 12/11/28

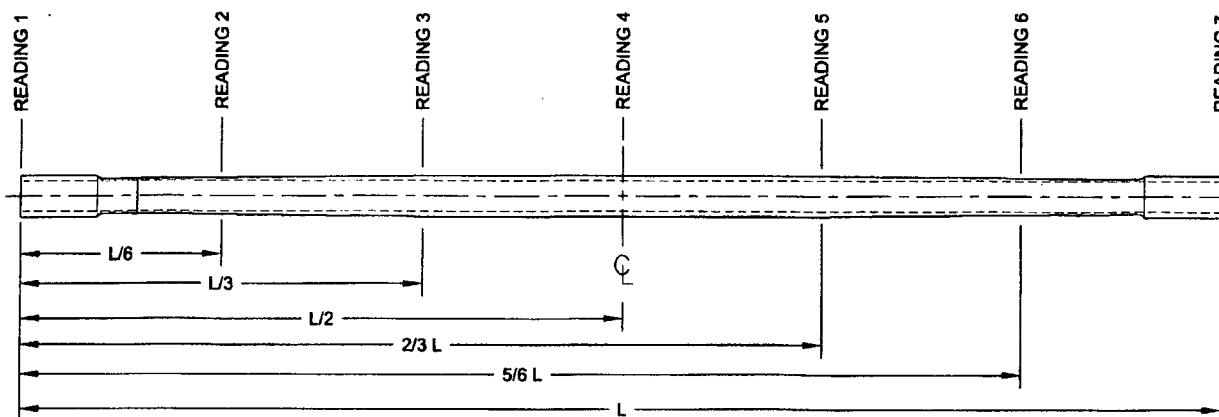
Audited by: <i>[Signature]</i>
Date: 12-12-10

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	
D	11.07.26	Tolerance revised for 2.339 dimensions	KJ	
E	12.06.04	Wall thickness form added	KJ	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 84656
Description: Crosstube Assembly (AS350/355 High Fwd)	Part Number: D350-748-141
Inspection Dwg: D350-748-141 Rev: F	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L= 0"	.133	.137	.129	.121	.016	0.030"
READING 2 L= 12	.085	.095	.120	.110	.035	
READING 3 L= 22	.133	.135	.160	.161	.028	
READING 4 L= 55	.182	.184	.191	.190	.009	
READING 5 L= 22	.157	.141	.137	.152	.020	
READING 6 L= 11	.172	.190	.093	.115	.025	
READING 7 L= cuff	.178	.127	.118	.127	.020	

Calibration Result

Actual Block Thickness: .100 .500

Sitiescan 250 Measured Thickness: .100 .500

Measured by: JMM	Audited by:	Preliminary Approval:
Date: 13/01/23	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	
B	07.10.24	Dwg Rev updated	KJ/EC/DD	
C	11.01.20	Dwg Rev updated	KJ	
D	11.07.26	Tolerance revised for 2.339 dimensions	KJ	
E	12.06.04	Wall thickness form added	KJ	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description -	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

Item	Qty	Part Number	Description
	-141		
1	X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
2	1	D6015-125	CROSSTUBE (OR D6017-115)
3	2	D3502-1	SUPPORT
4	2	D2856-400-710	ABRASION STRIP
5	1	AELS-1032-225	INSERT
6	1	NAS1149D0363J	WASHER (OR AN960JD10)
7	2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
8	1	MS27039-1-10	SCREW

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6015-125 OR D6017-115
FINISHED LENGTH = 110.270±0.06
- 2) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: DART PART NUMBER "D350-748-141" AND BATCH NUMBER ON INSIDE OF CUFF
PER DART QSI 044 6.4 (VIBRATING STYLUS)
- 7) WEIGHT: 30.45 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR Ø0.297 HOLE.
- 9) BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING. ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 40-45 HRC.
- 12) INSTALL D2856-400-710 ABRASION STRIPS WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 13) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 14) TORQUE CLAMPS 60 TO 80 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.
- 15) MAX TWIST AFTER BENDING: WITH XTUBE LAYED FLAT ON SURFACE, THE DIFFERENCE BETWEEN CUFF HEIGHTS FROM THE SURFACE MAY BE NO LARGER THAN 0.25 (ZN C1-3).

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WITHOUT NOTICE
WORK ORDER
NO. 84656 MCT

12/05/31 UNDER REVIEW

11.07.12

RELEASED
2011-01-18

F	ADD HRC TEST OPTION (B8-1) PER PAR 09-040, ADD TWIST LIMIT (A8-1, C1-3), ADD D6015-125 OPTION (C8-1), STOCK DIM NOW MACHINED (D1-4)	CP	10.11.23
E	REVISE GENERAL NOTES; UPDATE TO CURRENT ADD STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); TOLERANCES (ZN C6-3, D1-3)	RF	09.09.30
D	MAG. PARTICLE AND CAD PLATE AS MFD.	CP	06.10.31
C	ADD CAD PLATING	CP	06.08.14
B	ADD D6017-115 & PRIME AND PAINT	CP	06.06.30
A	NEW ISSUE	CP	06.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D350-748-141	REV. F SHEET 1 OF 4
TITLE CROSSTUBE (AS 350/355 HI FWD)	SCALE NTS
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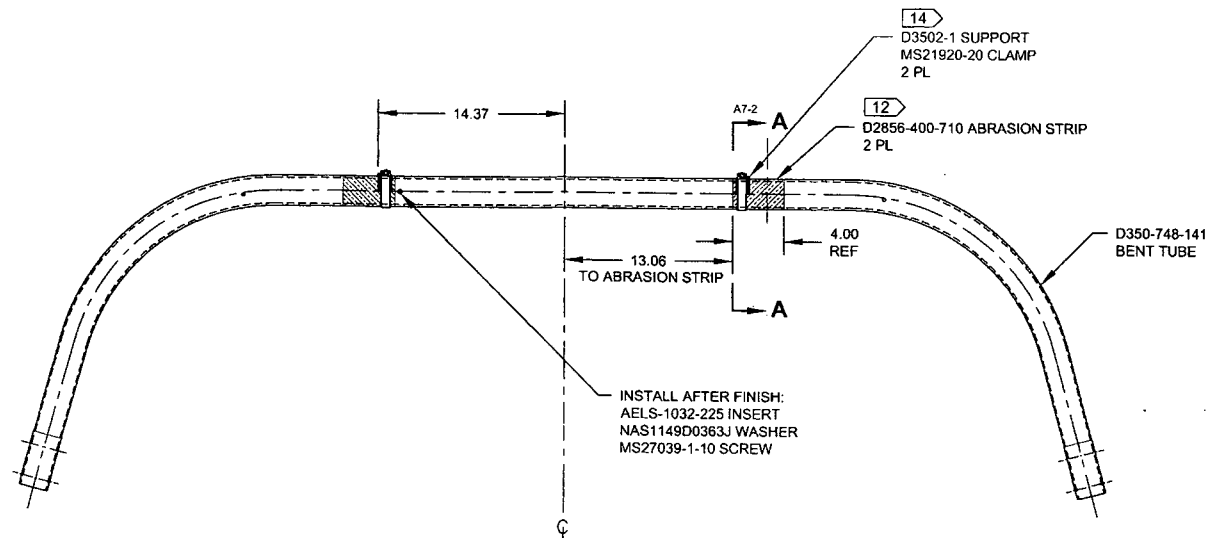
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

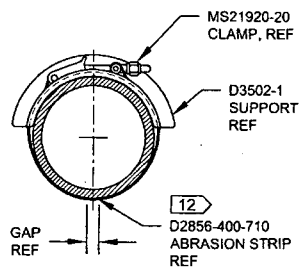
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D350-748-141
ASSEMBLY DETAIL**



SECTION A-A D4-2
SCALE 4X

UNDER REVIEW

11.07.11

RELEASED
2011-01-18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D350-748-141	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE (AS 350/355 HI FWD)	NTS
DATE	10.11.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

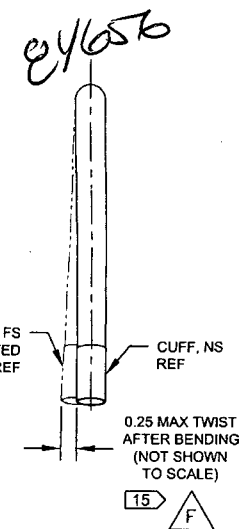
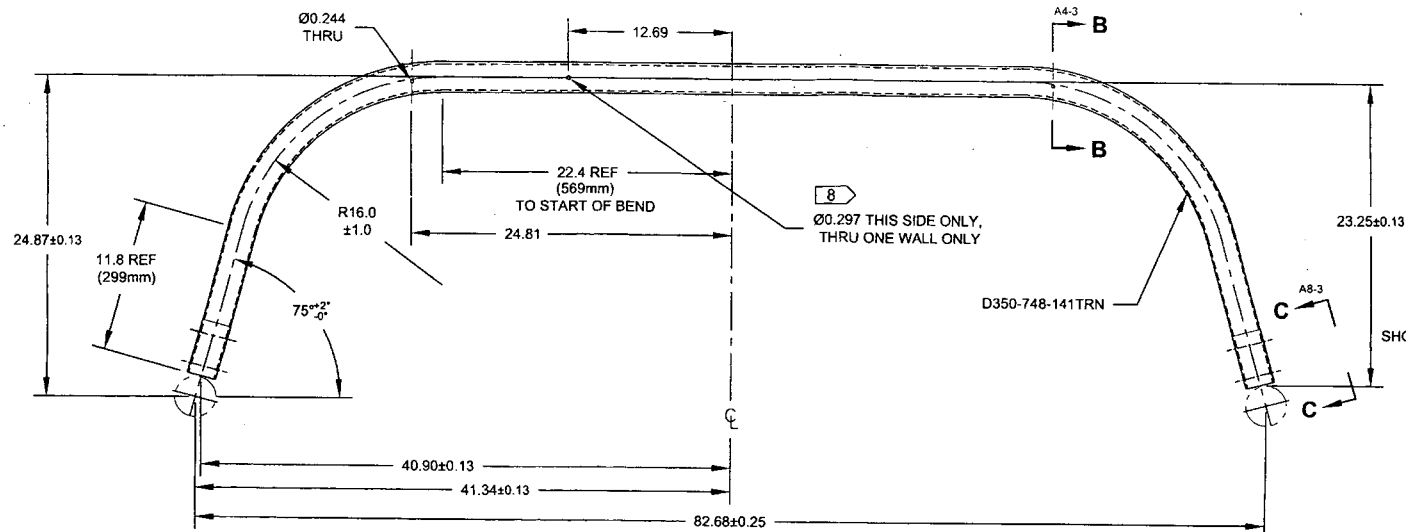
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

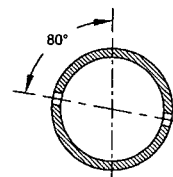
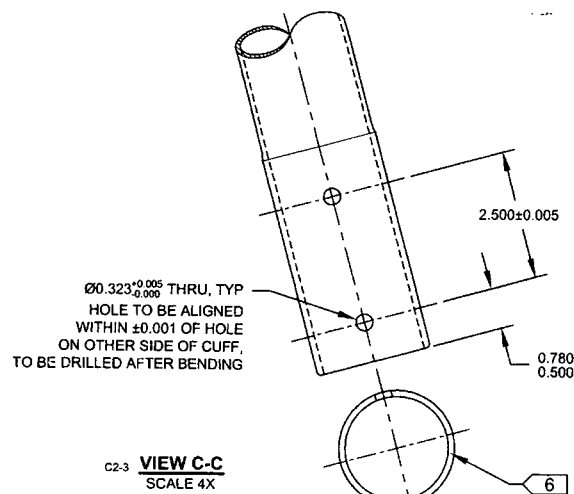
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-748-141
BENDING AND DRILLING DETAIL 10



UNDER REVIEW
 11.27.12

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 2011-01-18

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	13	D350-748-141	SHEET 3 OF 4
APPROVED	13	TITLE	SCALE
DE APPR.	13	CROSSTUBE (AS 350/355 HI FWD)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

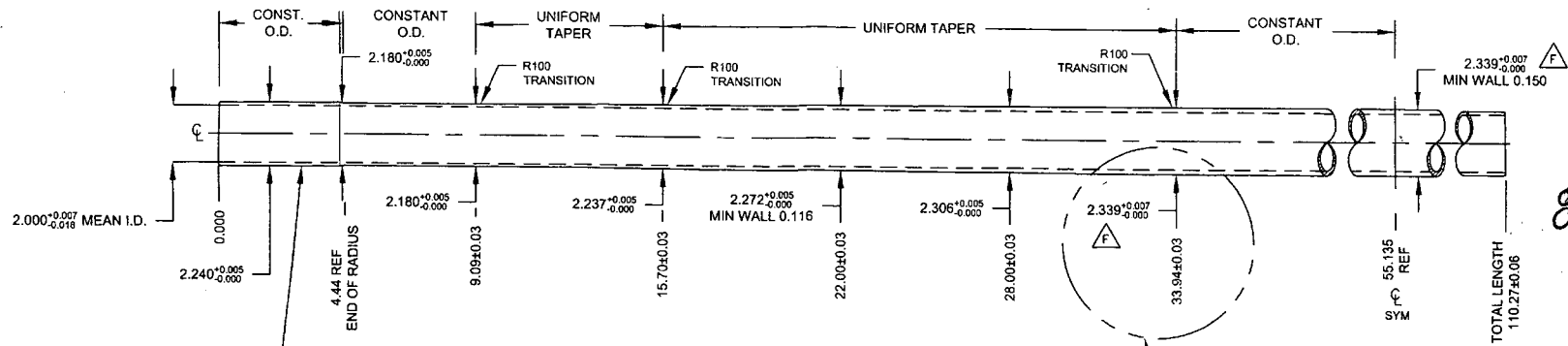
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



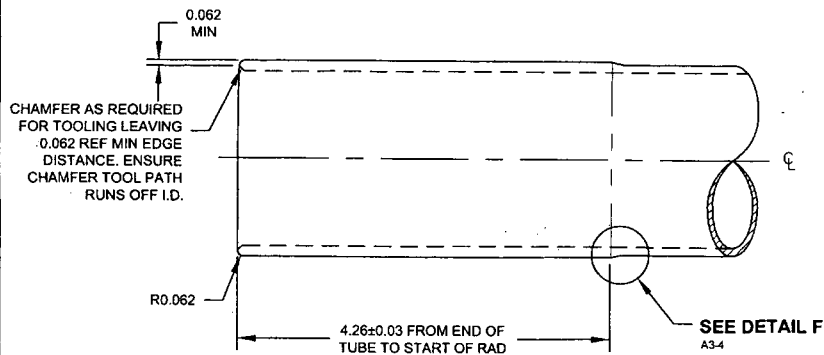
SEE DETAIL D
A6-4

SEE DETAIL E
A1-4

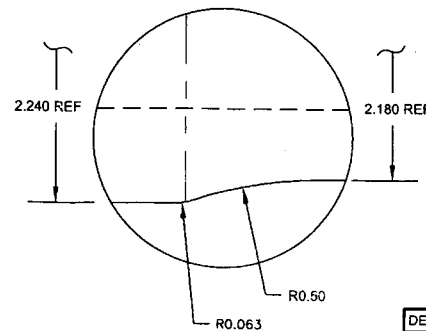
UNDER REVIEW

11.07.12

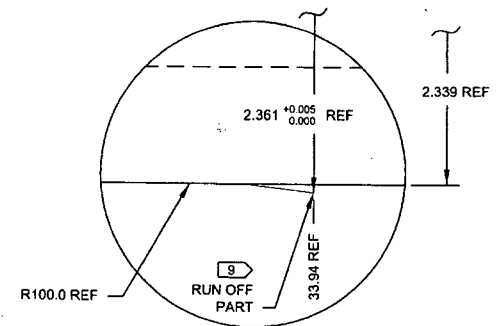
**D350-748-141TRN
TURNING DETAIL**



**DETAIL D:
CROSSTUBE CUFF** C7-4
SCALE 3X



**DETAIL F:
CUFF TRANSITION** A5-4
NOT TO SCALE



**DETAIL E:
TAPER RUN-OFF** C3-4
NOT TO SCALE

RELEASED
2011-01-13

DESIGN	9P	DART AEROSPACE LTD	
DRAWN	9P	HAWKESBURY, ONTARIO, CANADA	
CHECKED	13	DRAWING NO.	REV. F
MFG. APPR.	13	D350-748-141	SHEET 4 OF 4
APPROVED	13	TITLE	SCALE
DE APPR.	13	CROSSTUBE (AS 350/355 HI FWD)	NTS
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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

METLAB
- 1000 E. MERMAID LANE
WYNDMOOR, PA 19038

Packing List

Sales Order Number:

75193

Sales Order Date

Dec 26, 2012

Page:

2

Voice: 215-233-2600
Fax: 215-233-5653

Sold To:
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

Ship To:
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7

Customer ID	PO Number	Payment Terms
DARA	PO18654	Net 30 Days
	Ship Via	Process
	R & L CARRIERS	

Quantity	Item	Description	Total Shipped	This Shipment
1.00		D350-748-241TRN 1 PC. 91185		
1.00		D350-748-241TRN 1 PC. 84656		
1.00		D350-748-141TRN 1 PC. 91170		
1.00		D350-748-141TRN 1 PC. 91184		
1.00	CERT.	D350-748-241TRN HEAT TREAT TO MIN 180 KSI (MIL-T-6736 OR AMS 2759-1C) SANDBLAST AFTER HEAT TREAT 400 POUNDS TOTAL		

COMMENTS

SHIPPED BY, SIGNATURE
METLAB

DATE

RECEIVED BY, SIGNATURE
DART AEROSPACE

DATE



1000 E. Mermaid La., Wyndmoor (Phila.) PA 19038-8093
Tel. (215) 233-2600 Fax (215) 233-5653

Certification

SOLD TO

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

January 10, 2013

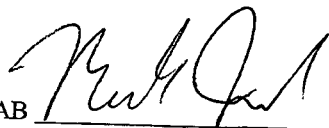
Metlab Shop Order No:	75193
Purchase Order:	PO18654
Description:	Cross Tube
Part No.:	D350-748-241/141
Quantity:	11 Pieces
Weight:	400 Pounds
Material:	4130 Alloy Steel
Specifications:	Harden and temper to 180 KSI minimum ultimate tensile strength

This is to certify that the above parts were processed as indicated above and conform to the specification requirements.

Results:

Ultimate Tensile Strength: 194/208 KSI*

*Converted from 42/44 HRC surface hardness


METLAB
Quality Representative Mark Jenkins

MERCURY CONTAMINATION: During the heat treating process, testing and inspections, the product did not come in direct contact with mercury or any of its compounds nor with any mercury containing device.



Heat Treating and Metallurgical Consulting

D 350 X-TUBE CUFF MEASURMENTS AFTER HEAT TREATING

	TYPE	BATCH #	SIDE A TWO READINGS	SIDE B TWO READINGS
1	AFT	B89098	2.241"/2.251"	2.272"/2.214"
2	AFT	B91184	2.266"/2.221"	2.273"/2.212"
3	AFT	B91185	2.261"/2.220"	2.248"/2.234"
4	AFT	B89962	2.254"/2.234"	2.268"/2.212"
5	AFT	B79394	2.269"/2.212"	2.250"/2.243"
6	AFT			
7	AFT			
8	AFT			
9	AFT			
10	AFT			
1	FWD	B84655	2.268"/2.207"	2.246"/2.241"
2	FWD	B84656	2.253"/2.234"	2.242"/2.249"
3	FWD	B84657	2.271"/2.206"	2.251"/2.238"
4	FWD	B91177	2.244"/2.238"	2.262"/2.219"
5	FWD	B91170	2.255"/2.241"	2.285"/2.200"
6	FWD	B84658	2.272"/2.221"	2.256"/2.233"
7	FWD			
8	FWD			
9	FWD			
10	FWD			
11	FWD			
12	FWD			

DAS
16
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